

Tuesday, 28/08/2007 11:53:01 AM
Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 34284
Estimate Number : 10804
P.O. Number : *NIA*
This Issue : 28/08/2007 S.O. No. : *NIA*
Prsht Rev. : NC
First Issue : *NIA* Type : SMALL / MED FAB
Previous Run : 00015
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : *[Signature]*

Drawing Name : D2410
Part Number : D2410
Drawing Number : REWORK
Project Number : *NIA*
Drawing Revision : *NIA*
Material : *NIA*
Due Date : 04/09/2007

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
DISASSEMBLE D206-571-043 ASS'Y B/N 26886

FF 07-10-16

2

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
disassemble D2410 assembly as follows:
-remove D2403 outer skin
-D2375-3-08-106 insulation
-D2416 angle
-D2411

FF 07-10-16

2

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
-Pick 12x MS20600AD4W4 rivets B *M1105792*
-replace the split rivets on the assembly

(7x)

FF 07-10-16

2

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect replaced rivets, as well as removed parts from the original assembly. *****Ensure no oversized holes*****

07-10-16 (2)

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2410

Job Number: 34284

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

-Pick :

8x MS20600AD4W2 M M 4747
2x MS20600AD4W3 M M 15318071
8x MS20470AD4-5 M M 104156

- Reassemble D2410 as per Dwg D2410

FF 07-10-23

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ensure all rivets are good

S 02/10/23 (42)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

-Scuff WHITE AREA ONLY

- Re-powder coat as per dwg **** masking off the unpainted area's ****

BR 07-10-24

M 105068

(2)

8.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

07-10-25 (2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- Proceed with W/O D206-571-043 B 26886 for assembly.

FF 07-10-26

(2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

S 07/10/09

Job Completion



9.5 QC 15 S 07/10/26

U 07-10-29



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2410	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY	
A	95.04.06	NEW ISSUE	
A1	RF 03.04.29	ADDED FLARE	

RELEASED
11/19/10 BW

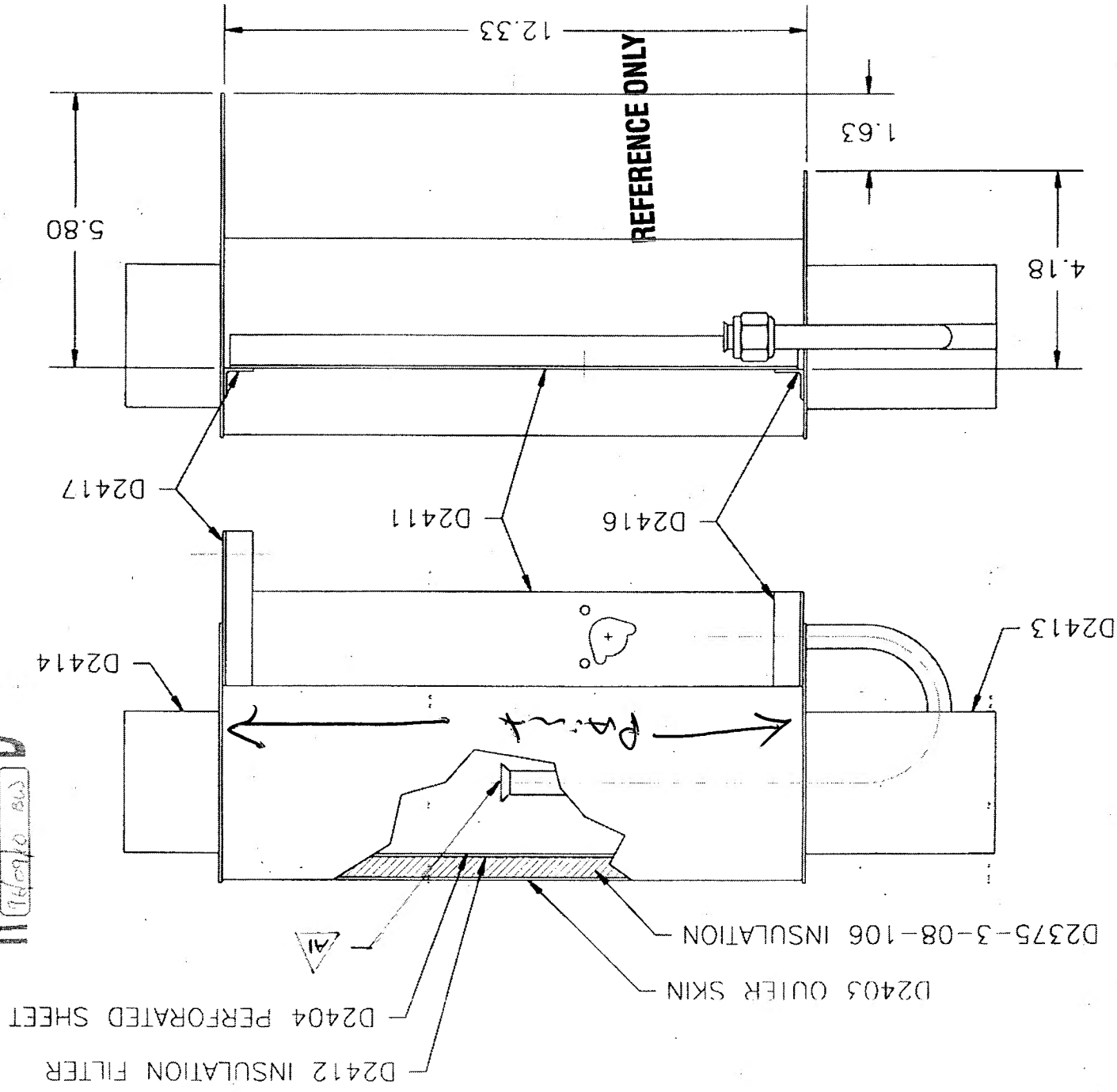
QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS20600AL4WZ	RIVET CR 9163-4-2
6	MS20600AD4W3	RIVET CR 9163-4-3
12	MS20600AD4W4	RIVET CR 9163-4-4
8	MS20470AD4-5	Rivets

REFERENCE ONLY



PREPARED		DART AERO ACCESSORIES INC	
B. Williams		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	D2410	REV. A SHEET 2 OF 2
BW	BW		
DATE	TITLE	SCALE	
Apr. 6, 1995	206 ASPIRATOR ASSEMBLY		

RELEASED
R 960910 BW



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/22	5	Replaced insulation on Both heaters. D 2375-3-08 (M1810)		Destroyed both insulation	FF 07/10/22			
07/10/22	5	Replaced ms 20600 AD4W3 with CR 32434-4 (M104252)				07-10-23	05/10/22	07-10-23
07/10/22	5	Replaced outer skin D 2403 with new one D 2403 (B 26904) 12 CR 32434-4 (M104252)		destroyed old ones	FF 07/10/23	07-10-23	05/10/22	07-10-23
		4 CR 3243-4-2 (M102601) RE: Clamps dent material.		Replace D2411 B24398 B25066				
07-10-23	S.O	The hole was oversized on the D2411 on 1 ASS'y, when the rivet was removed. - 1 more D2411 B24398 scrap		Qty 1, and re-assemble.			05/10/22	07-10-23

NOTE: Date & initial all entries